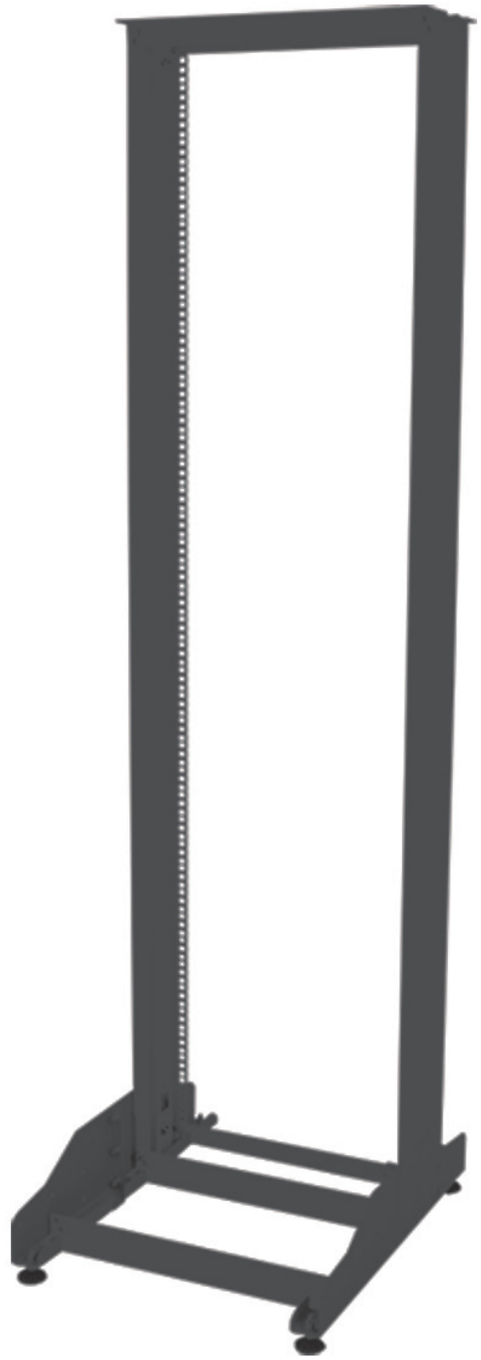
SINGLE-FRAME RELAY RACK
ASSEMBLY INSTRUCTIONS



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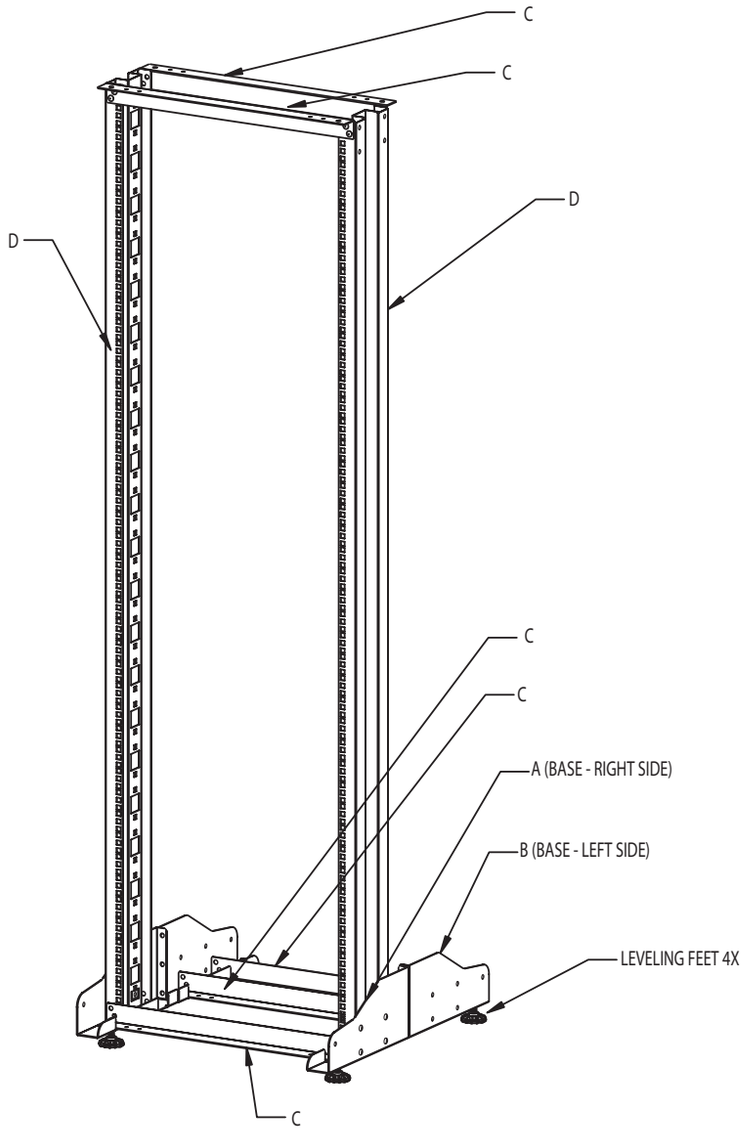
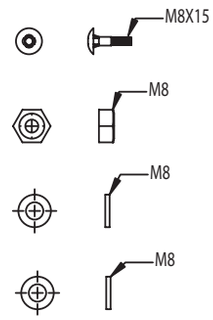
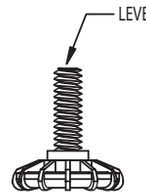
Single Frame_ass_instrux.indd 1 10/26/06 9:21:36 AM

Single Rack Parts List



ASSEMBLY HARDWARE





TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	> =	Linear dim.	Broken edges	<	> =	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

PART NO.	PART DESCRIPTION	QUANTITY INCLUDED
A	Base, Right Side	2
B	Base, Left Side	2
C	Horizontal Support	5
D	Vertical Rack Rail	2
LEVELING FEET	Leveling Feet	4
M8X15	Channel Screw	32
M8	Nut	32
M8	Washer	32
M8	Spring Washer	32

REV				
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE				
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO.	SHEET OF
DRAWN				REV 00
CHECKED				

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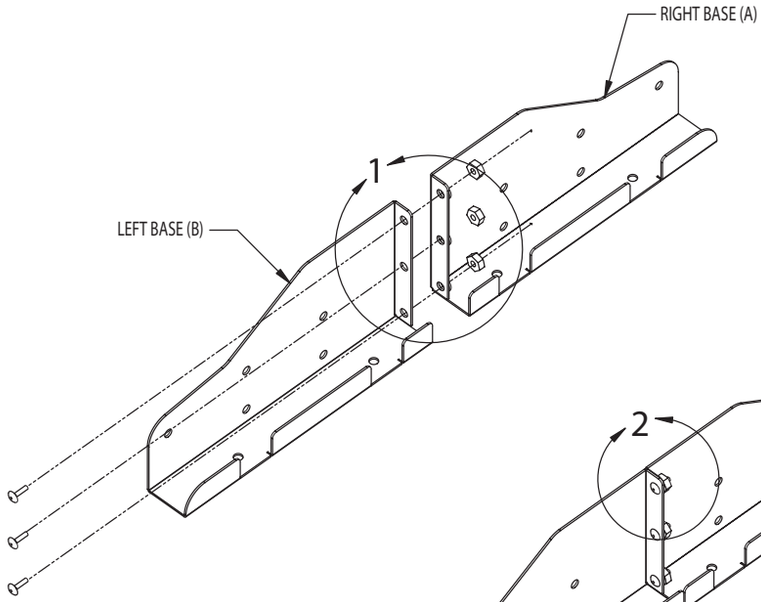
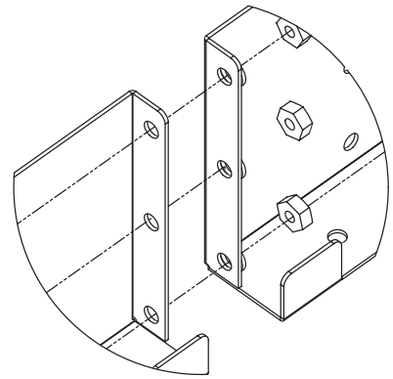
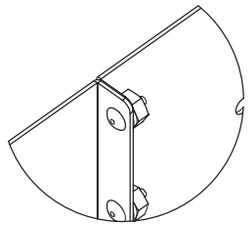
Step 1 — Assemble the Base





DETAIL 1
SCALE 1 : 2



DETAIL 2
SCALE 1 : 2

TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	>=	Liner dim.	Broken edges	<	>=	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Join one piece of right base A with one piece of left base B using the M8X15 screws, washers, spring washers and nuts as shown in Details 1 & 2. Repeat the process for the other set of A & B.

REV			
00			
ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST			
MATERIAL: CRS1110 (A1)	FINISH		
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		SINGLE FRAME RELAY RACK ASSEMBLY INSTRUCTIONS	
DO NOT SCALE DRAWING			

APPROVALS	DATE	SIZE	DWG NO	SHEET OF	REV
DRAWN:			STEP_1		00
CHECKED:					

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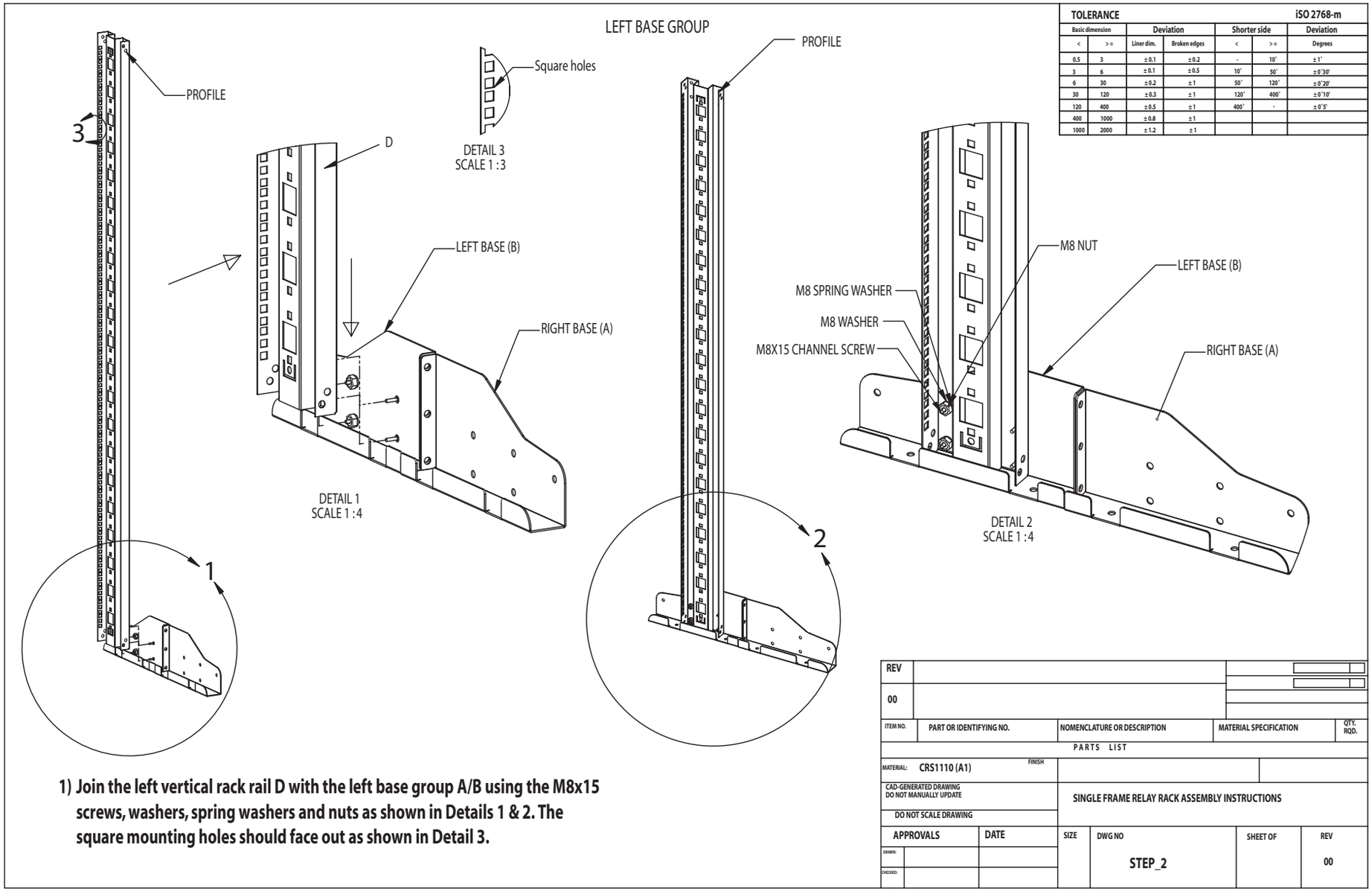
Step 2 — Assemble the Left Vertical Rack Rail



TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	> =	Liner dim.	Broken edges	<	> =	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

REV				
00				
ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		SINGLE FRAME RELAY RACK ASSEMBLY INSTRUCTIONS		
DO NOT SCALE DRAWING				

APPROVALS	DATE	SIZE	DWG NO	SHEET OF	REV
DRAWN:			STEP_2		00
CHECKED:					

1) Join the left vertical rack rail D with the left base group A/B using the M8x15 screws, washers, spring washers and nuts as shown in Details 1 & 2. The square mounting holes should face out as shown in Detail 3.

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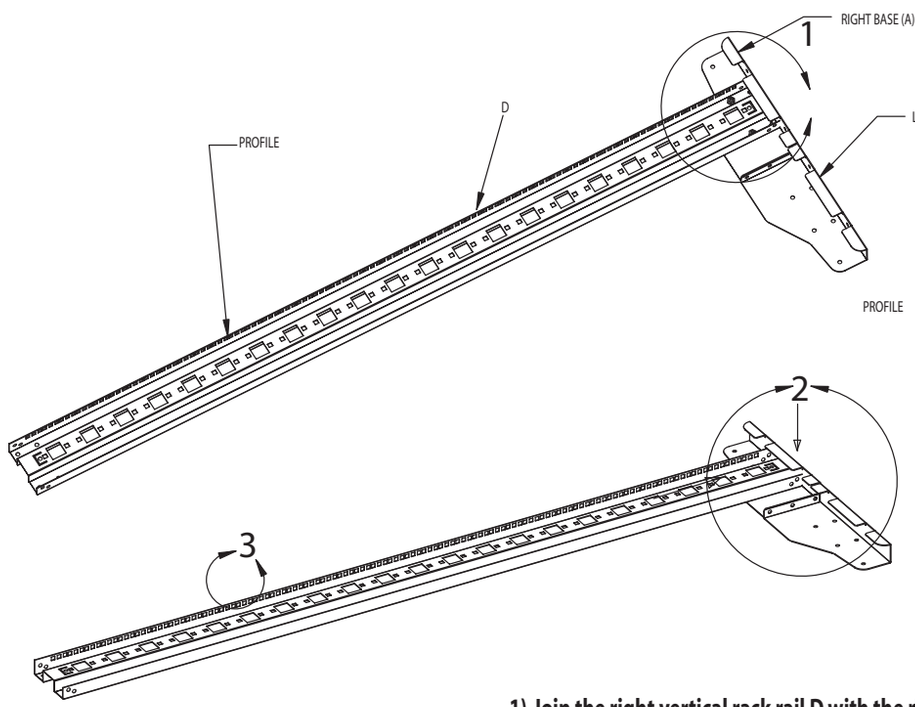
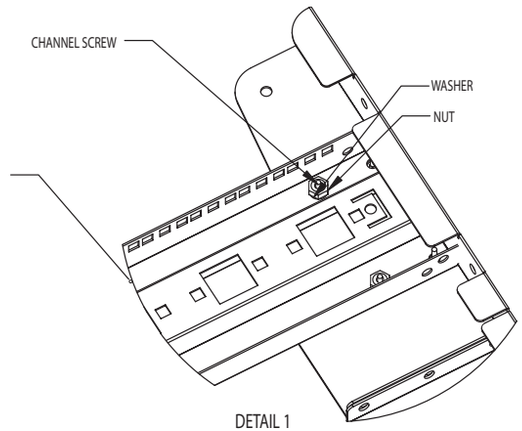
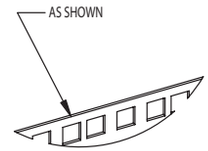
Step 3 — Assemble the Right Vertical Rack Rail

RIGHT BASE GROUP

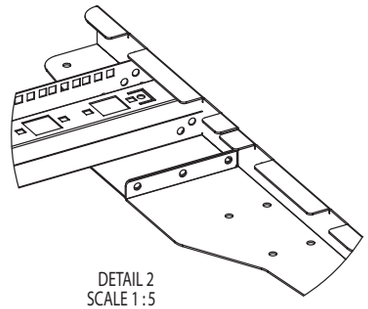




DETAIL 1
SCALE 1 : 3.5



DETAIL 3
SCALE 1 : 2



DETAIL 2
SCALE 1 : 5

TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	>=	Liner dim.	Broken edges	<	>=	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Join the right vertical rack rail D with the right base group A/B using the M8x15 screws, washers, spring washers and nuts as shown in Details 1 & 2. The square mounting holes should face out as shown in Detail 3.

REV			
00			
ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST			
MATERIAL: CRS1110 (A1)	FINISH		
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		SINGLE FRAME RELAY RACK ASSEMBLY INSTRUCTIONS	
DO NOT SCALE DRAWING			

APPROVALS	DATE	SIZE	DWG NO	SHEET OF	REV
DRAWN:			STEP_3		00
CHECKED:					

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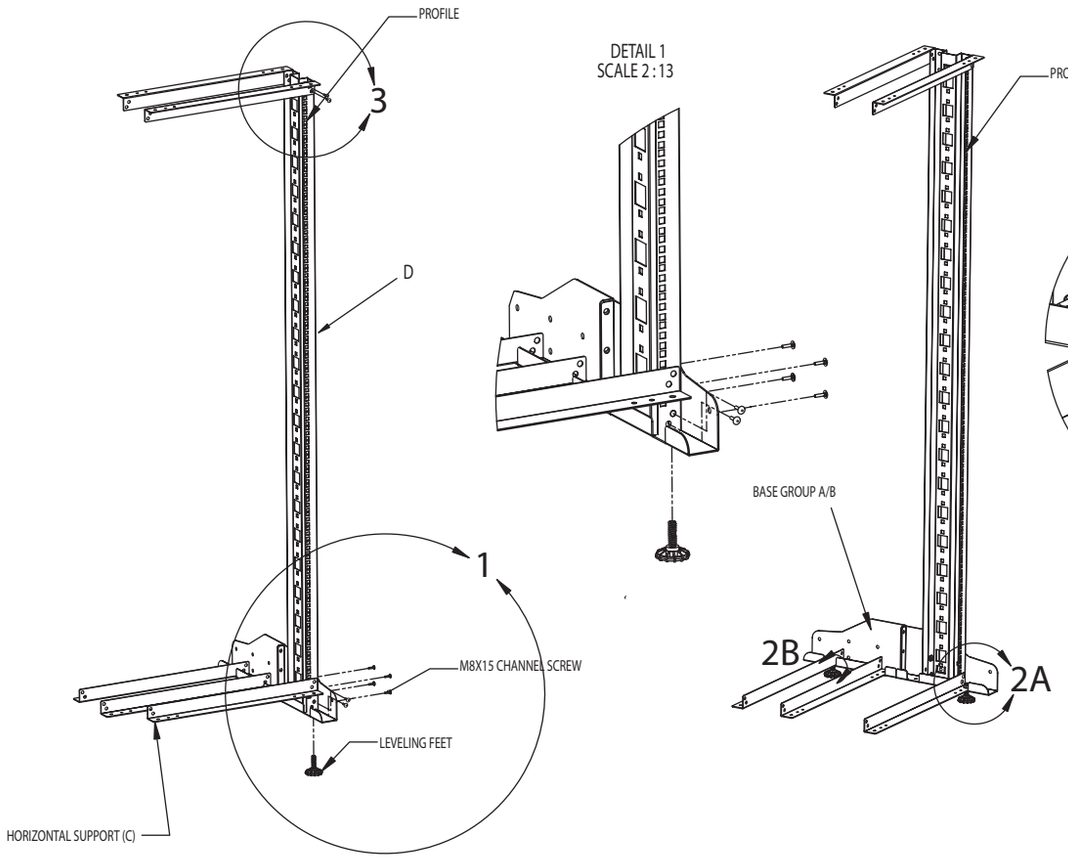
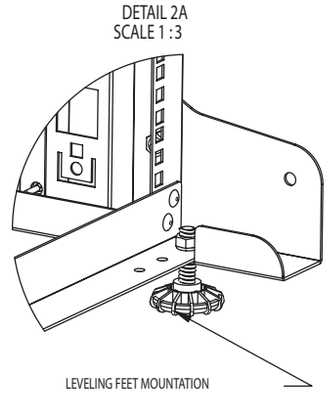
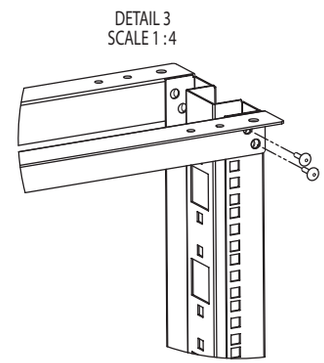
Step 4 — Assemble the Horizontal Support Rails







TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	> =	Liner dim.	Broken edges	<	> =	Degrees
0.5	3	± 0.1	± 0.2	-	10˚	± 1˚
3	6	± 0.1	± 0.5	10˚	50˚	± 0˚30'
6	30	± 0.2	± 1	50˚	120˚	± 0˚20'
30	120	± 0.3	± 1	120˚	400˚	± 0˚10'
120	400	± 0.5	± 1	400˚	-	± 0˚5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Attach three horizontal support rails C to the bottom right-side rack assembly using the M8x15 screws, washers, spring washers and nuts as shown in Detail 1.
2) Attach the leveling feet to the bottom of the rack assembly using the M8 washer and nut as shown in Details 2A & 2B.
3) Attach two horizontal support rails C to the top right-side rack assembly using the M8x15 screws, washers, spring washers and nuts as shown in Detail 3.

REV			
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST			
MATERIAL: CRS1110 (A1)	FINISH		
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		SINGLE FRAME RELAY RACK ASSEMBLY INSTRUCTIONS	
DO NOT SCALE DRAWING			
APPROVALS	DATE	SIZE / DWG NO: STEP_4	SHEET OF	REV: 00
DRAWN				
CHECKED				

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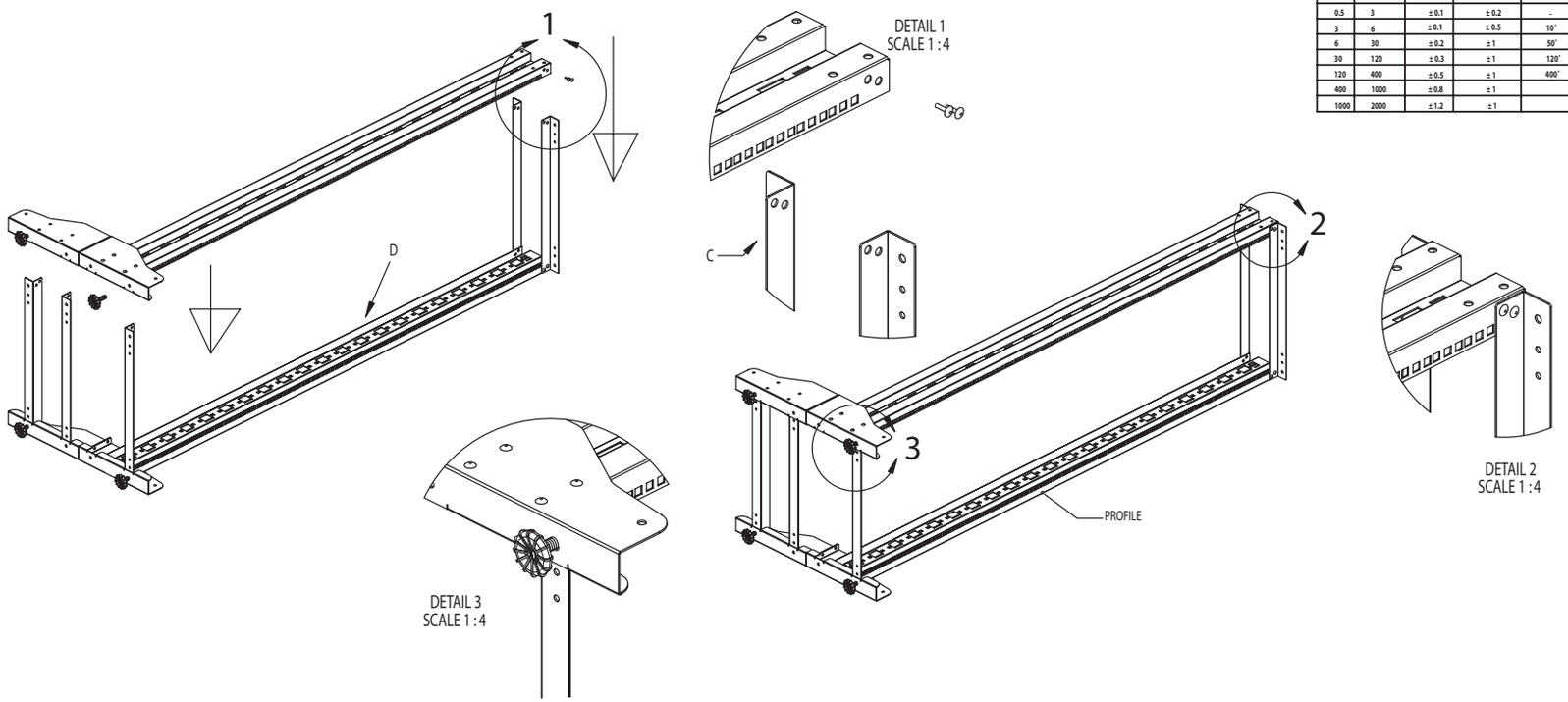
Step 5 — Assemble the Open Rack



TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	> =	Liner dim.	Broken edges	<	>=	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Join the left-side rack assembly to the right-side rack assembly by attaching the right-side support rails to the left using the M8x15 screws, washers, spring washers and nuts as shown in Details 1 & 2.
2) Attach the leveling feet to the bottom of the left-side rack assembly using the M8 washer and nut as shown in Detail 3.
3) Stand the rack upright on the leveling feet and firmly tigthen all nuts and bolts.

REV				
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		SINGLE FRAME RELAY RACK ASSEMBLY INSTRUCTIONS		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF / REV
DRAWN:			STEP_5	00
CHECKED:				

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